

Work Order ID 53077

October 22, 2009 3:48:24 PM



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Item ID: D2410

Accept



Setup Start



Revision ID: A1

Stop



Item Name: 206 Aspirator Assembly

Start Date: 21/10/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 04/11/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *[Signature]*

Date: 09-10-22

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2410

Rev A1

100

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Assemble D2413, D2414 and D2404 as per dwg D2410

SB 10/04/24

(2)

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SB 10/04/26

(4)

120

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Install the rest of assembly parts as per dwg D2404

SB 10/11/08

m-l 10/11/08

(2X)

PTO

W/O: 53077

WORK ORDER CHANGES

Dave already
has it in
BOM.















DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/04/26	100	Add D2375-3-08-106 x1 per Kit B.M. 1810	mf	10-4-26	2		

Part No: D2410 PAR #: Fault Category: NCR: Yes No DQA: Date:

Resolution: Disposition: QA: N/C Closed: Date:

NCR: 53077

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/06/26	100	after installing find out skin had a dent had to remove skin & replace +		Scrap & destroy D 2403 + rivet replace		 10/06/26	 10.06.26 01042	 10/06/26
		Rivet CR 3243 - #4 M or CR 3243 #3	10/04/25	D2403 B 59378	10/10/02  10/06/11	 11/11/11		 10/11/11
10/11/09	120	part measure is at 4.32 Suppose to be at 4.180 because part D2413 is crooked	 09/11/09	Install D2411 to match best fit	 10/06/11	 10.11.11	 09/11/09	 10.11.11

NOTE: Date & initial all entries

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Item ID:	D2410	Accept		Setup	Start	
Revision ID:	A1				Stop	
Item Name:	206 Aspirator Assembly					
Start Date:	21/10/2009	Start Qty:	2.00		Cust Item ID:	
Required Date:	04/11/2009	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	8 10/11/17			<u>12</u>			
140 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum in 115951 Memo ****Place masking tape on red anodize tube of flare section and access to interior of both ends **** START TIME: 2:25 TEMPERATURE: 320° FINISH TIME: 2:55	0.00 0.00				<u>2</u>		BR 10-12-13.	
150 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00	=> M 10/12/11			<u>2</u>			

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Item ID: D2410	Accept		Setup	Start	
Revision ID: A1				Stop	
Item Name: 206 Aspirator Assembly					
Start Date: 21/10/2009	Start Qty: 2.00		Cust Item ID:		
Required Date: 04/11/2009	Req'd Qty: 2.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Packaging Packaging	Identify as per dwg & Stock Location: <u>CA</u> Memo <u>B 64720</u>	0.00 0.00				<u>(2)</u>			
170 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					<u>10/12/14</u>		<u>[Signature]</u>

W 10.12.14

Picklist Print

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Work Order ID: 53077

Parent Item: D2410RevA1

Parent Item Name: 206 Aspirator Assembly


Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2403RevA  Heater Outer Sheet		Manufactured	No			100	Each	4.0000	2.0000		SB 10/11/02	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1

35815

1

Main Warehouse

ST232B

3

50242

3

D2404RevA

Manufactured

No

100

Each

0.0000

2.0000



B 53524



2 SB 10/11/02

Heater Perforated Sheet

D2411RevB

Manufactured

No

100

Each

16.0000

2.0000



SB 10/11/02

Valve Support

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

16

24398

9

25066

7

2

Picklist Print

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Work Order ID: 53077

Parent Item: D2410RevA1

Parent Item Name: 206 Aspirator Assembly



Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:



Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2412RevA  Insulation Filter		Manufactured	No			100	Each	9.2700	1.5346 			



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	9.27	
17099	4.27	
31028	5	

2 SB 10/11/02

D2413RevA  Instake Weldment Assembly		Manufactured	No			100	Each	2.0000	2.0000 			
---	--	--------------	----	--	--	-----	------	--------	---	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2	
29312	2	

2 SB 10/11/02

D2414RevA  Outlet Weldment Assembly		Manufactured	No			100	Each	3.0000	2.0000 			
--	--	--------------	----	--	--	-----	------	--------	---	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	3	
46836	3	

2 SB 10/11/02

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Work Order ID: 53077

Parent Item: D2410RevA1

Parent Item Name: 206 Aspirator Assembly

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2416RevB		Manufactured	No			100	Each	14.0000	2.0000			

Mounting Angle

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	14	
35968	14	

D2417RevB

Manufactured No

100 Each 14.0000 2.0000



Mounting Angle

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	14	
35969	14	

MS20470AD4-54

Purchased

No

100 Each 2,943.000 16.0000



Rivet, Universal Head

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	2943	
111916	2943	

115470

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Work Order ID: 53077

Parent Item: D2410RevA1

Parent Item Name: 206 Aspirator Assembly


Start Date: 21/10/2009

Required Date: 04/11/2009

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item / Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20600-AD4W2		Purchased	No			100	Each	484.0000	16.0000			
												
Rivet												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

484

109059

84

111359

200

112794

200

16 SB 10/11/09

MS20600-AD4W3

Purchased

No

100

Each

2,539.000 4.0000



Cherry Rivets

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2539

102929

37

104715

10

106375

524

107939

1000

111636

968

4 SB 10/11/09

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Work Order ID: 53077



Parent Item: D2410RevA1



Parent Item Name: 206 Aspirator Assembly

Start Date: 21/10/2009

Required Date: 04/11/2009

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS20600-AD4W4		Purchased	No			100	Each	2,495.000	24.0000			

Rivets

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

2495

110731

215

111359

46

111477

74

112314

1960

112385

200

4 113368

24

SB 10/11/02



PREPARED		DART AERO ACCESSORIES INC	
B. Williams		VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	D2410	REV. A
BW	BW		SHEET 1 OF 2
DATE		TITLE	SCALE
Apr. 6, 1995		206 ASPIRATOR ASSEMBLY	
A	95.04.06	NEW ISSUE	
A1	RF 03.04.29	ADDED FLARE	

RELEASED
9669/10 BW

QTY	Part No.	Description
X	D2410	B206 ASPIRATOR ASSEMBLY
1	D2375-3-08-106	INSULATION
1	D2403	OUTER SKIN
1	D2404	PERFORATED SHEET
1	D2411	VALVE MOUNTING ANGLE
1	D2412	INSULATION FILTER
1	D2413	INTAKE ASSEMBLY
1	D2414	OUTLET ASSEMBLY
1	D2416	MOUNTING ANGLE
1	D2417	MOUNTING ANGLE
8	MS20600AD4W2	RIVET (CR 9163-4-2)
2	MS20600AD4W3	RIVET (CR 9163-4-3)
12	MS20600AD4W4	RIVET (CR 9163-4-4)
8	MS20470AD4.5	Rivets

M 1810

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53077

109-10-22

DART

PREPARED B. Williams		DART AERO ACCESSORIES INC VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	D2410	REV. A SHEET 2 OF 2
DATE Apr. 6, 1995		TITLE 206 ASPIRATOR ASSEMBLY	

RELEASED
96/09/0 BW

